

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022512**Date Inspected:** 11-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Trial Assembly:

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

Repair welding of weld joint no: Seg3013AD-076 [X4394B stiffener on Floor Beam (FB) 3193A to Side Panel (SP3092E), complete joint penetration (CJP) weld at panel point (PP) 119+1500]. The welder is identified as 020598 and was observed welding in the 4G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC Quality Control (QC) was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per Critical Welding Repair Report (CWR): 2875 Rev-0.

The SMAW process on weld joint no: Seg3013-004 [Deck Panel (DP) Sub-Assembly (SA) 7510A to DP3124A, CJP weld]. The welder is identified as 069683 and was observed welding in 4G position. ZPMC QC was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with WPS:

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B-P-2214-B-U2-FCM-1.

OBG Seg 13BW:

The SMAW process on weld joint no: DP3138-001-084 (DP3138A to DP diaphragm, CJP weld at PP121). The welder is identified as 045196 and was observed welding in 4G position. ZPMC QC was identified as Shi Lei. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-Tc-U4b-FCM-1.

The SMAW process on weld joint no: DP3137-001-046 (DP3137A to DP diaphragm, CJP weld at PP121). The welder is identified as 045196 and was observed welding in 4G position. ZPMC QC was identified as Shi Lei. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-Tc-U4b-FCM-1.

This QA Inspector observed that ZPMC personnel had performed fit-up of FB stiffener X3859B with FB stiffeners; X4495H and X4950D (on FB3217A at PP122). This QA Inspector verified this fit-up as per drawing. It was observed that the fit-up of X3859B FB stiffener with FB3217A was made as fillet weld joint. However, as per WD191AG, this weld is required as CJP weld with backing bar (to remain). This QA Inspector informed this to ZPMC QC identified as Wang Xiang Ping and ABF QA identified as Cao Hui Zhao. ZPMC QC agreed that they will remove this X3859B stiffener and will do the fit-up again with bevel prepared as per drawing. See attached photo for further details.

OBG Seg 13CW:

This QA Inspector observed that ZPMC personnel had performed fit-up of FB stiffener X3859B with FB stiffeners; X4450D and X4450H (on FB3220A at PP122.5). This QA Inspector verified this fit-up as per drawing. It was observed that the fit-up of X3859B FB stiffener with FB3220A was made as fillet weld joint. However, as per WD191AG, this weld is required as CJP weld with backing bar (to remain). This QA Inspector informed this to ZPMC QC identified as Wang Xiang Ping and ABF QA identified as Cao Hui Zhao. ZPMC QC agreed that they will remove this X3859B stiffener and will do the fit-up again with bevel prepared as per drawing. See attached photo for further details.

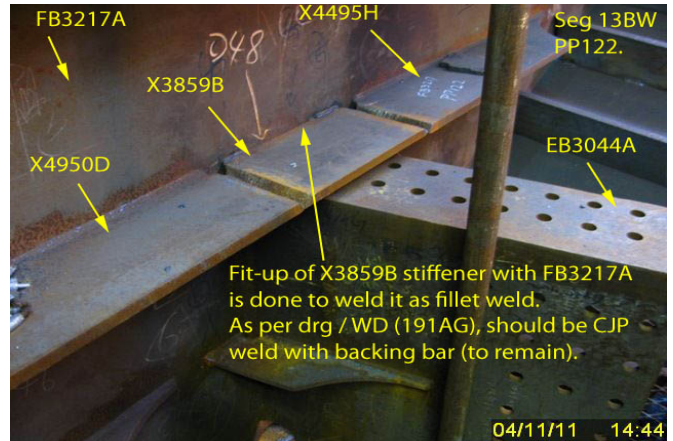
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable Contract documents.

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### Summary of Conversations:

No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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**Inspected By:** Wadkar,Sailesh

Quality Assurance Inspector

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**Reviewed By:** Peterson,Art

QA Reviewer